

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE BILLET (6061)
Job Number	: 35951		
Estimate Number	: 12482		
P.O. Number	: N/A	Part Number	: D6102013
This Issue	: 11/21/2007 S.O. No. : N/A	Drawing Number	: D6102 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: M/A Type : PURCHASED PARTS	Drawing Revision	: D
Previous Run	: 35605	Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 12/5/2007 Qty: 30 Um: Each
Checked & Approved By	: <u>[Signature]</u>		
Comment	: Est Rev. A New Issue 06-07-03 JLM		

Job Number:

Seq. #:	Machine Or Operation:	Description :
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10 PG PURCHASING

Comment: Issue P/O: 8111 c207111

- a) Description: Aluminum Billet
- b) 7.000" x 6.500" x 2.000" thick
- c) Tolerance on all dimensions is +0.06/0.00
- d) Grain direction along 6.500" length
- e) Material: 6061-T6/T6511 (QQ-A-250/11 or QQ-A-200/8)

Material release certificate is required

2.0 D6102013P 6061-T6 7.0x6.5x2.0

Comment: Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s)
6061-T6 6.0x11.0x5.0 3.00" x 6.50" L

30 PACKAGING 1 PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Receive & Inspect For Transit Damage
Ensure material certification is attached

40 QC6 DIMENSIONAL CHECK

Comment: DIMENSIONAL CHECK
Check certification to Dwg D6102 for compliance

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 01/12/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 1:16:21 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BILLET (6061)

Job Number: 85951

Part Number: D6102013

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(30)

Comment: FINAL INSPECTION/W/O RELEASE

2007/12/11

Job Completion



2007/12/11 cy

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

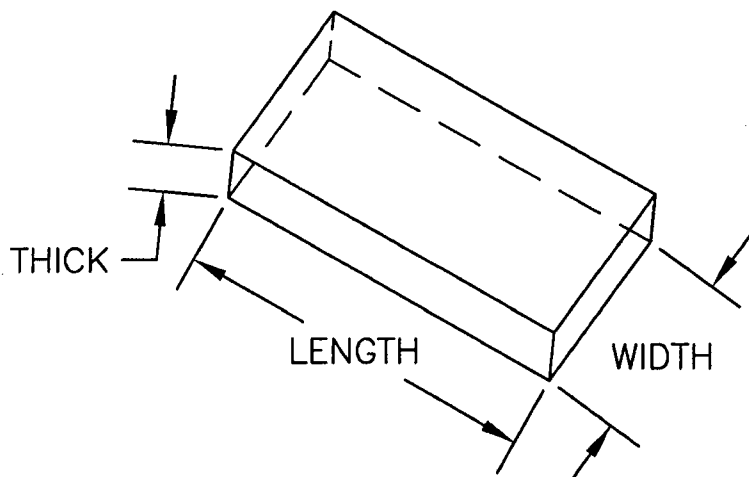
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D6102	Rev. D SHEET 1 OF 1
DATE 06.06.30		TITLE SADDLE BILLET, 6061	SCALE NTS
A	01.03.30	NEW ISSUE	
B	03.10.20	ADD D6102-005/-007/-009	
C	04.08.25	ADD D6102-010/-011	
D	06.06.30	ADD D6102-013	

SPECIFICATION CONTROL DRAWING



RELEASED

06.08.15 #

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.06/-0.00), AND GRAIN DIRECTION AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.06/-0.00.

ALL DIMENSIONS ARE IN INCHES.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35951

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6102-001	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	7.880	6.250	2.000	Along 7.880 Length
D6102-003	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	6.000	6.250	2.000	Along 6.000 Length
D6102-005	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	47.85	15.250	1.000	Along 47.85 Length
D6102-007	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	7.500	7.000	2.500	Along 7.500 Length
D6102-009	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	11.000	6.000	5.000	Along 11.000 Length
D6102-010	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	7.950	8.250	2.500	Along 7.950 Length
D6102-011	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	6.500	8.250	2.500	Along 6.500 Length
D6102-013	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	6.500	7.000	2.000	Along 6.500 Length

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NO. COM. CLIENT-CUST. ORD. NO.		COMPT. ACCT.		VEND. SLS	TERR.	EXPEDIE PAR SHIP VIA	DATE 03 DEC 2007	
TELEPHONE		H/C	TAXE	NO. COM. ORD.	REGION LIVRAISON-DEL. ZONE		F.A.B.-F.O.B.	BILL
RE A-SHIP TO:								NO. FEVILLE/EMBALLAGE-B/L NUMBER

VENDU A-SOLD TO:		INFORMATION CREDIT-CREDIT INFORMATION		POLITE	
INSTRUCTIONS LIVRAISON-DELIVERY		INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.)		INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.)	
DESCRIPTION - ITEM 1					

CERTIFICATE OF CONFORMANCE		INSTRUCTIONS		COULÉE INFO-HEAT INFO QTE-QTY		QTE/UNITE COM.-ORDERED		POIDS COM.-WT. ORDERED	
A.M. Castle & Co. certifies that the material(s) supplied under this document will meet and conform to the specifications of the product(s) described hereon. A.M. Castle & Co. (Canada) Inc.		THICKNESS TOL: 1.00mm / .004" GRAIN TO RUN ALONG 6.00" PRIN DIST/ORD: 41 468239 7/12/07		16296-01-00		1		30	
WEIGHT FOR SHIPPING PURPOSES ONLY. SEE INVOICES FOR ACCURATE BILLING WEIGHT. PLEASE SIGN AND DATE DRIVER'S COPY FOR RECEIPT OF MATERIAL AND, IF CHECKED, TEST REPORTS.				INSTRUCTIONS (CONT'D.)		FORME-SHAPE		I.A.C.	
				30x7x6.5"		N3		ENT-WHSE.	
DESCRIPTION - ITEM 2									

TERMS AND CONDITIONS OF SALE		INSTRUCTIONS		COULÉE INFO-HEAT INFO QTE-QTY		QTE/UNITE COM.-ORDERED		POIDS COM.-WT. ORDERED	
SEE DISCLAIMERS AND LIMITATIONS ON THE REVERSE SIDE		1 BOX				BALLOTS-BUNDLES		POIDS EXP.-WT. SHIPPED	
				INSTRUCTIONS (CONT'D.)		FORME-SHAPE		I.A.C.	
								ENT-WHSE.	
DESCRIPTION - ITEM 3									

EXCEPTIONS FOR SHORTAGE OR DAMAGE MUST BE NOTED BY THE DRIVER COPY & CUSTOMER COPY OF THE DELIVERY INPTS & SIGNED BY THE DRIVER & CUSTOMER. COPY OF RECEIPT PROPERLY NOTED MUST BE SUBMITTED WITHIN 15 DAYS WHEN CREDIT IS REQUESTED.		INSTRUCTIONS		COULÉE INFO-HEAT INFO QTE-QTY		QTE/UNITE COM.-ORDERED		POIDS COM.-WT. ORDERED	
DATE RECEIVED BY						BALLOTS-BUNDLES		POIDS EXP.-WT. SHIPPED	
				INSTRUCTIONS (CONT'D.)		FORME-SHAPE		I.A.C.	
								ENT-WHSE.	

FEVILLE/EMBALLAGE

Abnahmeprüfzeugnis 3.1 (EN 10204)
Inspection certificate – mill certificate

AMAG rolling GmbH

Zertifiziert nach / certified to ISO/TS 16949, EN 9100, ISO 14001

Nr.: 85431828 01 / 1

Rev. 0

Seite / page: 1 von / of 1

Datum / date: 2007 10 10

Auftraggeber / customer: Castle, A M & Co (Inc) + Castle Metals 3400 N Wolf Rd USA-60131 FRANKLIN PARK, IL Warenempfänger / consignee: Castle, A M & Co (Inc) + Castle Metals 3400 N Wolf Rd Endkunde, Bestell-Nr. / Your cust., ord. no.:	Bestell Nr. / order no.: 01-84708
	Datum / date: 2007 08 06
	Auftragsbest. Nr. / order confirm. no.: 575917
	Datum / date: 2007 08 07
	Lieferschein Nr. / delivery note: 85431828
	Datum / date: 2007 10 16
Akkreditiv Nr. / letter of credit no.:	

Produkt/product	Bedingungen/terms
Form / form: plates, stretched Werkstoff / material: 6061 Zustand / temper: T651 Dim. / dim: [inch]: 2,000x48,50x144,50 Kundenartikel-Nr / customer article no.: 8641	Techn. Lieferbedingungen / techn. spec.: ASTM B 209-04, AMS-QQ-A-250/11-97, ASME SB-209-04 Sondervorschrift / special terms:

AB-Pos. ord.-Pos.	BNr/Los/Teillos Lot/No./Part	Guss Nr. cast no.	Werkstoff material	Kollo packno.	Gewicht netto weight net	Stk. pcs.
01	16296/01/00	01/0024261/7	6061	5759170001	4197,531 lbs	3
01	16296/01/00	01/0024261/7	6061	5759170002	1404,321 lbs	1

Chemische Zusammensetzung / chemical composition: [%] Gewichtsanteile / weight proportion

Guss Nr. / cast no.	AMAG designation	Al	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti
01/0024261/7	6061	97,38	0,64	0,47	0,22	0,12	0,9	0,16	0,01	0,03	0,05

Zugversuch / Tensile test

BNr/Los/TL Lot/No./Part	Zustand temper	Richtung direction	Tests		Rm [ksi]	Rp0.2 [ksi]	A2" [%]			
16296/01	T651	LT	6	Min	47,0	38,3	16			
16296/01	T651	LT		Max	47,6	39,3	17			

Bemerkungen / notes

Herstellerland: Österreich / goods origin: The goods are of Austrian origin.

Material erfüllt auch die mechanischen Eigenschaften von AMS 4027M, ist aber nicht gestempelt. / Material meets also the mechanical properties of AMS 4027M, but not marked.

Es wird bestätigt, dass die Lieferung geprüft wurde und den Vereinbarungen bei der Bestellung entspricht.

We hereby certify that the material described above has been tested and complies with the terms of the order contract.

Werkssachverständiger / factory specialist	E-Mail / e-mail
Josef Klampfer	j.klampfer@amag.at

Maschinell erstellt - Gültig ohne Unterschrift / Automated - valid without being signed